

Date: Wednesday, 8/30/2006 11:57:24 AM
 User: Kim Johnston

Example
Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : GASKET |
| Job Number | : 28360 | | |
| Estimate Number | : 12510 | | |
| P.O. Number | : N/A | Part Number | : D35221 |
| This Issue | : 8/30/2006 S.O. No. : N/A | Drawing Number | : UNDER REVIEW CB 06.09.30 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : SMALL /MED FAB | Drawing Revision | : N/A |
| Previous Run | : N/A | Material | : N/A |
| Written By | : <i>[Signature]</i> | Due Date | : 9/6/2006 Qty: 1 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> 06.08.30 | | |
| Comment | : Est Rev:A New Issue 06-08-21 JLM | | |

Additional Product

PRELIMINARY ISSUE

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|----------------------|
| 1.0 | MNEO50S031 | NEOPRENE SHEET 0.031 |
|-----|------------|----------------------|



Comment: Qty.: 0.0368 sf(s)/Unit Total : 0.0368 sf(s)

6064 T6 .040 Sheet

(M6064T6S040)

Batch:

Neoprene sheet - 0.031" thick

0.125" 0.063" 60 Diameter B20359 batch: 16.11.19

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: *Rev 1*

Prog Rev: *Rev 1*

Ensure Grain Direction is correct** N/A

2-Deburr if necessary

08 09 08 08 09 20

① ①

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08 09 20

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

06.09.19

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Form Joggle as per Dwg D3514

N/A

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 8/30/2006 11:57:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 28360

Part Number: D35221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 06.09.19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

not required

CB

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/03/09

Job Completion



U 07.03.09

*Engineering Approval
Project Manager*

*CB
07.03.08*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

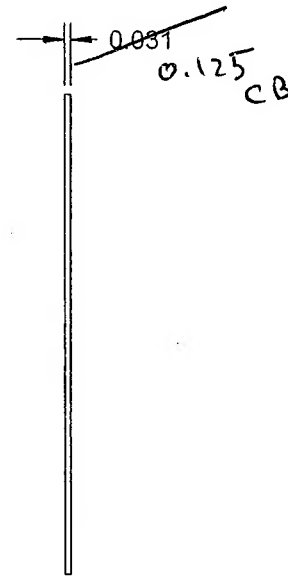
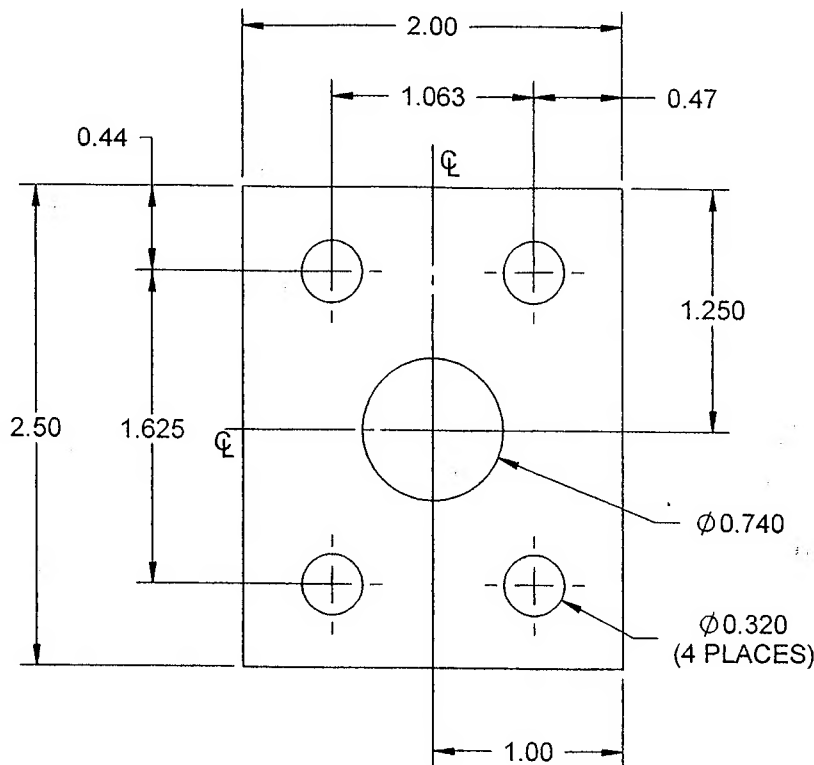
PRELIMINARY ISSUE

| | | | |
|------------------|---------------------------------|---|------------------------|
| DESIGN CB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3522 | REV. A SHEET 1 OF 1 |
| DATE 06.05.08 | TITLE GASKET SCALE 1:1 | | |
| A | 06.05.08 | NEW ISSUE | |

UNDER REVIEW

06.08.22 CB

prototype



D3522-1 GASKET

NOTES:

- 1) MATERIAL: 1/32 (0.031) THICK NEOPRENE SHEET (REF. DART SPEC. M-NEO50-8.031)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT ϕ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
28360

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Fax: 604-274-1013
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PACKING SLIP

00111072

CUSTOMER NO.

20750

PST# OCP

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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

8-20359

| | | | | | |
|-----------------------|---------|-----------------------------------|----------|-------------------------------------|----|
| DATE | | SHIP VIA | | TERMS | |
| 12/10/04 | | PURG GROUND AIR | | ACR GROUP INC. NET 30 DAYS | |
| PURCHASE ORDER NUMBER | | DATE ORDERED | | SALES PERSON | |
| 2006073 | | 07/15/04 | | GARYS | |
| QUANTITY | | ITEM NUMBER | | DESCRIPTION | |
| ORDERED | SHIPPED | B.O. | | | |
| 10 | 10 | | NEO60-02 | NEO 60-1/8" | SF |
| | | | | RS: 6'X100' | |
| | | | | LBS/SQFT: .9675 | |
| | | | | END A LETTER OF COMPLIANCE WITH P/S | |
| | | | | SUBTOTAL | |
| | | | | GST | |
| | | | | TOTAL AMOUNT | |

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Telephone (604) 274-9955
Fax (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 02/16/2004

Customer : Dart Aerospace LTD

Customer P.O. # : 2006078

Specification: Neo 60-1/8"

Customer Ref.# / Stock # : _____

Serial # : _____

ACR W.O. # : 111072

Item # : NEO 60-02

Item Description: NEO 60-1/8"


ACR Compound: _____

Date Shipped: 2/16/04

Carrier: PUROLATOR AIR

B / L : _____

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.


(ACR GROUP INC. REPRESENTATIVE)

DART AEROSPACE LTD

Work Order: 20359

Description: Neoprene 1/8" thick

Part Number: D3195

Dwg: D3195 Rev. A page 1

Qty: 50

Ref:

Page 1 of 1

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----|----------|-----|
| 1 | DC | Issue Traveler | RJ | 04.02.12 | 50 |
| 2 | PG | Issue P/O 2006076 Material: 60° Durometer Neoprene 1/8" thick Possible Supplier: Accurate Rubber, roll 12" x 50' length | U | 04.02.12 | 50 |
| 3 | RG | Receive and Inspect for transit damage | Q | 04.02.17 | 50 |
| 4 | QC6 | Inspect dimensions 12" x 1/8" thick 48 RB | RB | 04.03.22 | 50 |
| 5 | ST | Identify and Stock | Q | 04.03.22 | 50 |
| 6 | AC | Cost / part 2.14 545 | SUC | 04.03.23 | 50 |
| 7 | DC | Close W/O 2.14 Inspect Level 21 | HA | 04.03.26 | 50 |

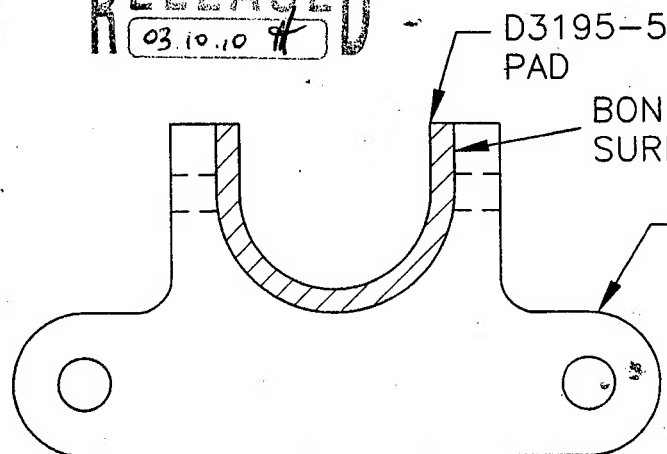
| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 03.10.17 | New issue | KJ/RF | RF |

RELEASED
04.01.12



| | | | | | |
|---------|----------|----------|----|-----------------------------|--------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD | REV. A |
| | | | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | # | APPROVED | # | DRAWING NO. D3195 | SHEET 1 OF 3 |
| DATE | 03.06.23 | | | TITLE BRACKET | SCALE 1:1 |
| A | 03.06.23 | | | NEW ISSUE | |

RELEASED
03.10.10

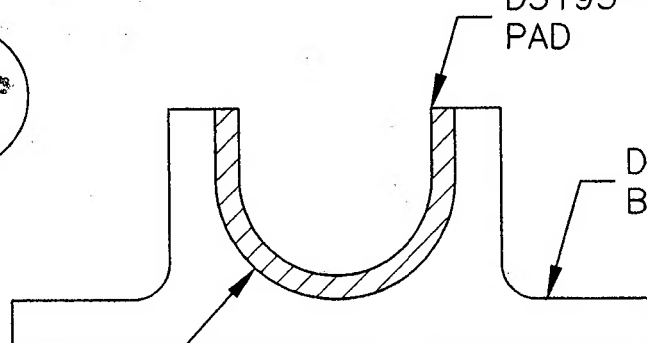


D3195-5
PAD

BOND TO ALUMINUM
SURFACE USING EPOXY

D3195-1
BRACKET

D3195-041
BRACKET

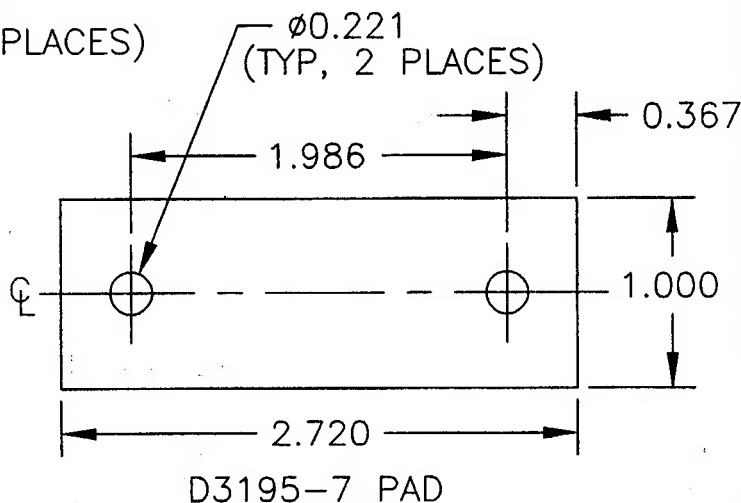
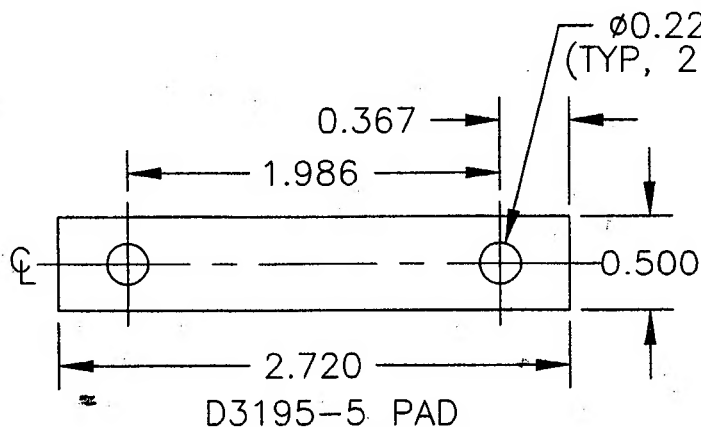


D3195-7
PAD

D3195-3
BRACKET

BOND TO ALUMINUM
SURFACE USING EPOXY

D3195-043
BRACKET



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 12, 2004
07:58 am

| | | | |
|-------------------|-----------------------|------------------|----------------|
| Work Order No | : 0020359 | Department Code: | |
| Project Name | : D3195 | Burden Flags | : NNNNNNNN |
| Project For | : WK407 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : D3195 | Invoice Number | : |
| Description | : Neoprene 1/8" thick | Invoice Amount | : 0.00 |
| Manufactured | : Yes | | |
| Amount Req'd | : 50 | Order Entry No | : |
| Amount Done | : 0 | OE Value | : 0.00 |
| Start Date | : 02-12-04 | | |
| Est Finish Date | : 02-20-04 | Est Margin | : 0.000% |
| Act Finish Date | : | Actual Margin | : 0.000% |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | | |

\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| ===== | | | | | |
| Material Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | : 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | : 0.00 | 0.00 | 0.00 | | |
| Production Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | : 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | : 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | : 0.00 | 0.00 | 0.00 | | |
| CNC | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | : 0.00 | 0.00 | 0.00 | | |
| Misc. | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| ===== | | | | | |
| Burden | : 0.00 | 0.00 | 0.00 | | |
| ===== | | | | | |
| Total Cost | : 0.00 | 0.00 | 0.00 | | |
| Margin | : 0.000 | 0.000 | | | |
| Selling Cost | : 0.00 | 0.00 | | | |

| | | |
|------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done | : 0.00 | 0.00 |
| Profits/(Loss) | : 0.00 | 0.00 |

ACR GROUP
Inc.

ACRrubber.com

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CUSTOMER NO. 10750

PST# OOP

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1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

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1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

| | | | | | | | |
|-----------------------|---------|------------------------|---|---|------|------------|--------|
| DATE | | SHIP VIA | | TERMS | | | |
| 02/16/04 | | PURC GROUND AIR | | ACR GROUP INC. NET 30 DAYS | | | |
| PURCHASE ORDER NUMBER | | DATE ORDERED | | SALES PERSON | | | |
| 0005073 | | 02/16/04 | | 00111072 GARYS | | | |
| QUANTITY | | | ITEM NUMBER | DESCRIPTION | UNIT | UNIT PRICE | AMOUNT |
| ORDERED | SHIPPED | B.O. | | | | | |
| 50 | 50 | - | NEO60-02 | NEO 60-1/8" RS: 4' X 100' LBS/SQFT: .9675 | SF | | |
| | | | 4' X 12.5' SEND A LETTER OF COMPLIANCE WITH P/S | | | | |
| | | | SUBTOTAL | | | | |
| | | | GST | | | | |
| | | | TOTAL AMOUNT | | | | |
| FREIGHT: Collect | | | | | | | |

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Fax (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 02/16/2004

Customer : Dart Aerospace LTD

Customer P.O. # : 2006078

Specification: Neo-60-1/8"

Customer Ref.# / Stock # : _____ Serial # : _____

ACR W.O. # : 111072 Item # : NEO 60-02


Item Description: NEO 60-1/8"

ACR Compound: _____

Date Shipped: 2/16/04

Carrier: PUROLATOR AIR B / L : _____

*This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.


(ACR GROUP INC. REPRESENTATIVE)